

Date: Friday, 2/23/2007 8:31:43 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HINGE BRACKET	
Job Number	30885				
Estimate Number	10345				
P.O. Number	N/A		Part Number	D28571	
This Issue	2/23/2007 S.O. No. N/A		Drawing Number	D2857 REV B	
Prsh Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	B	
Previous Run	29051		Material	N/A	
Written By			Due Date	3/24/2007 Qty: 24 Um: Each	
Checked & Approved By					
Comment	Est C 06.06.22 Removed P/O for powder coat EC				
	Est D 06.05.01 Added level 8 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
		Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s) Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B200001250) Batch M18818 / 8pcs M100451 / 17pcs
		 J.F. 07/03/16 25
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks 5.2"
		 J.F. 07/03/16 25
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2857-1
		 JL/J.F. 07/03/17 25
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
		 JL/J.F. 07/03/17 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/13/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 30885		Part Number: D28571
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SECOND CHECK		<i>m 07/03/18 25</i>
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble 2-Deburr any rough edges after tumbling		<i>SB 07/03/20 25</i>
8.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>m 07/03/20 25</i>
9.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3		<i>M 103706 - 07/03/20 25x</i>
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		<i>P 07/03/21 25</i>
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		<i>P 07/03/21 25</i>
12.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i> 07/03/23 25</i>
Job Completion		 <i> u 07/03/24</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30885
Description: Hinge Bracket	Part Number:	D2857-1
Inspection Dwg: D2857 Rev: AB		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

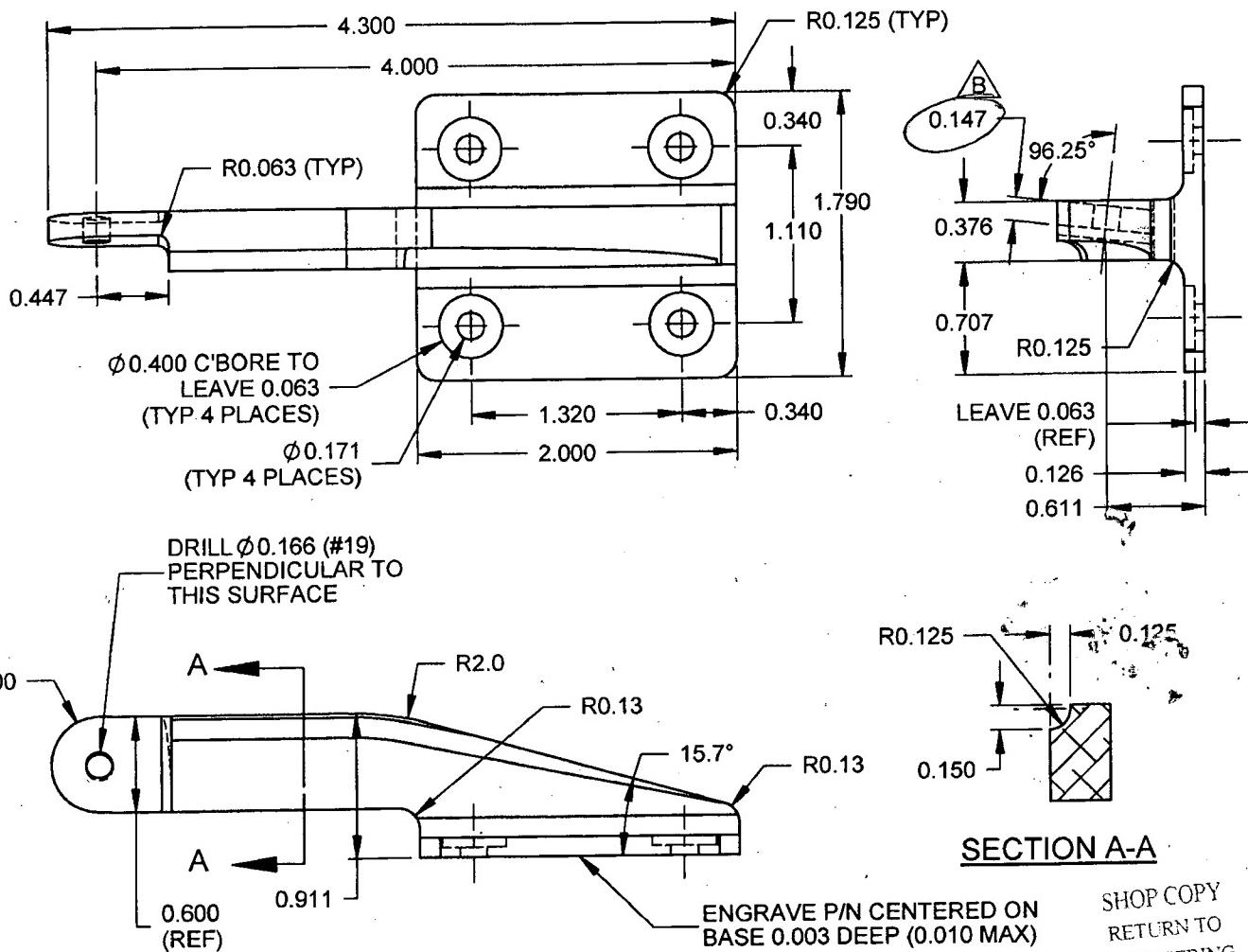
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.302	/			
0.340	+/-0.010	.340	/			
1.110	+/-0.005	1.110	/			
1.790	+/-0.010	1.792	/			
1.320	+/-0.005	1.320	/			
2.000	+/-0.010	2.002	/			
Ø0.171	+0.005/-0.000	.173	/			
0.147	+/-0.010	.140	/			
0.376	+/-0.010	.376	/			
0.126	+/-0.010	.125	/			
0.063	+/-0.010	.062	/			
Ø0.166	+0.005/-0.000	.167	/			
0.911	+/-0.010	.913	/			
0.600	+/-0.010	.606	/			
0.125	+/-0.010	.135	/			
0.150	+/-0.010	.153	/			

Measured by:	JL	Audited by:	JML	Prototype Approval:	N/A
Date:	07/03/17	Date:	07/03/17	Date:	N/A

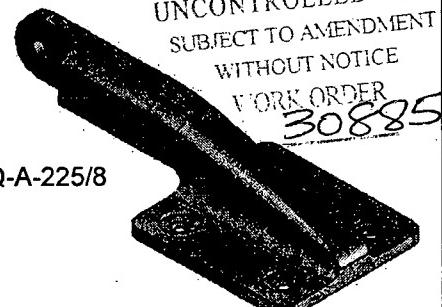
Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	JL

DART

DESIGN KE	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D2857	REV. B	SHEET 1 OF 1
DATE 06.08.28		TITLE HINGE BRACKET	SCALE 1:1	
REV A	DATE 98.12.14	DESCRIPTION NEW ISSUE		
REV B	DATE 06.08.28	DESCRIPTION ADD THICKNESS, REDRAW W/ SOLIDWORKS		

RELEASED
06-10-13

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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WORK ORDER
30885